

RE-Identify

Work Order ID 164626

164626

Page 1

Tuesday, July 25, 2017 12:44:10 PM

Item ID: D119-646-143

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: AW119 Repl. Skidtube with Wearplates & Wearpads, Float Comp. - Fits LH or RH

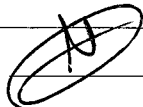
Start Date: 7/25/2017 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 7/26/2017 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan:  Date: JUL 24 2017

Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3905-043	E
IIN-D119-646	D

270 0.00

270

HandFinish
Hand Finishing

Memo
PULL FROM STOCK
D119-646-043 XI
B: M135877

1.90

in of all 12/07/25

280 QC5- Inspect part completeness to step on W/O 0.00

280

QC
Quality Control

Memo

0.02

DAS
38
9-89

JUL 25 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Work Order ID 164626

Tuesday, July 25, 2017 12:44:10 PM

164626

Page 2

Item ID: D119-646-143**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** AW119 Repl. Skidtube with Wearplates & Wearpads, Float Comp. - Fits LH or RH**Start Date:** 7/25/2017 **Start Qty:** 1.00 ***1*****Cust Item ID:****Required Date:** 7/26/2017 **Req'd Qty:** 1.00 ***1*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
290 *290* Packaging Packaging	Identify as per dwg & Stock Location: <i>u/o</i> Memo IDENTIFY UNDER D119-646-143 <i>163/90</i>	0.00 0.01				<i>H</i>			<i>17/07/25</i> DAS 36 9-89
300 *300* QC Quality Control	QC21- Final Inspection - Work Order Release Memo . . .	0.00 0.10		<i>CHG 004 ?</i>					<i>17/7/26</i> <i>[Signature]</i>

DAS
21
9-89**JUL 25 2017**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____			

Picklist Print

Tuesday, July 25, 2017 12:44:20 PM

Page 1

Work Order ID: 164626

164626

Parent Item: D119-646-143

D119-646-143

Parent Item Name: AW119 Repl. Skidtube with Wearplates & Wearpads, Float Comp. - Fits LH or RH

Start Date: 7/25/2017

Required Date: 7/26/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC IPP REVb
12.11.05 (DEOD3905-B-1)(ecn 12-675) DD verf:JLM IPP REV:C 13.03.20
per chg003 ECN13-534 DD verf:JLM IPP REV:D 15.01.19 AS PER ECN-
14-628 DD verf:JLM IPP REV:E 16.11.02 chg as per D3905
revD(DEO) DD verf:JLM IPP REV:F 17.05.19 as per dwg D3905 rev.e DD
verf:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D119-646-043		Manufactured	No				Each	2.0000		1			

D119-646-043

AW119 Replacement Skidtube with Wearpads, Float Compatible - Fits LH or RH

**

22 6/10/17

Location

Loc Qty

Loc Code

FG

2

135877

1

135879

1

x

DQA: _____ Date: _____

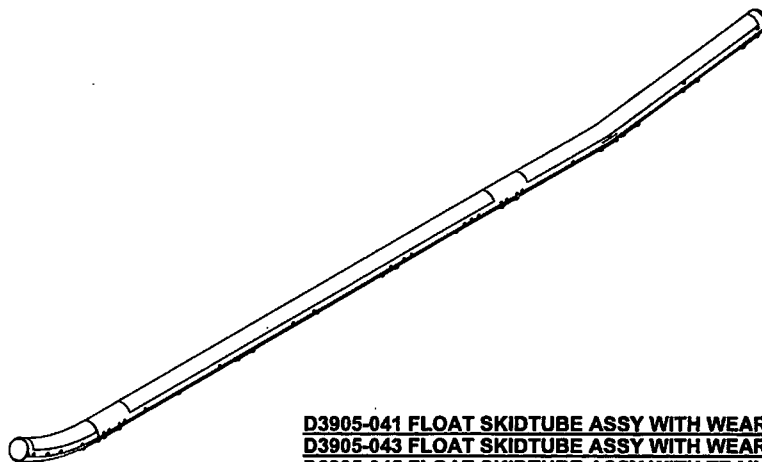


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : _____							



D3905-041 FLOAT SKIDTUBE ASSY WITH WEARPAD (SHOWN)
D3905-043 FLOAT SKIDTUBE ASSY WITH WEARPLATE (SIMILAR)
D3905-045 FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE (SIMILAR)

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED
 SUBJECT TO APPROVAL

WITHOUT
 WORK
 NO. 164626

JUL 25 2017

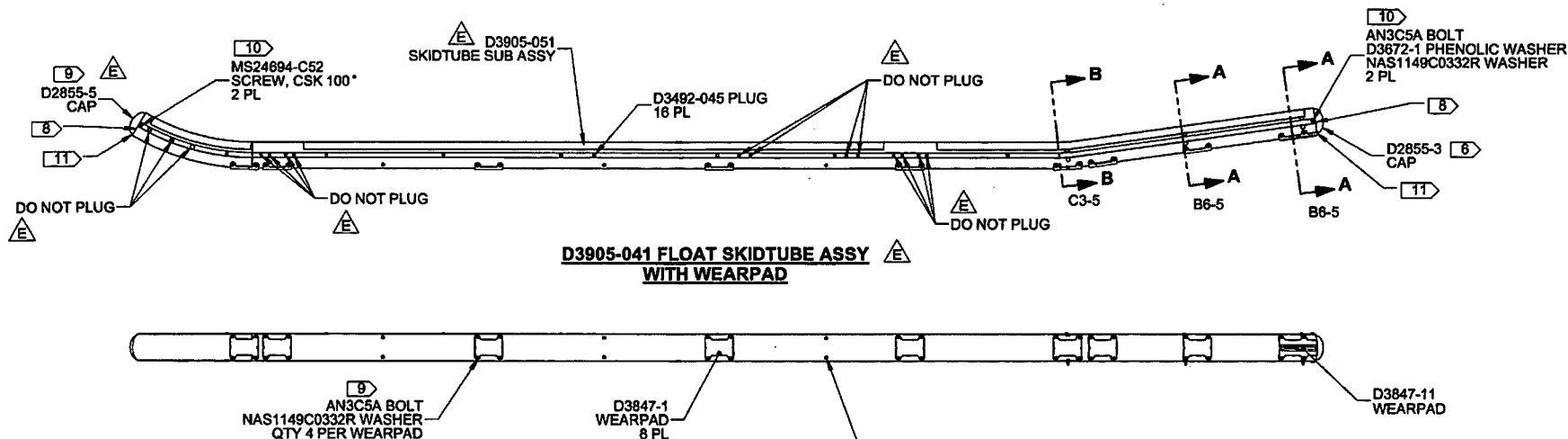
E	COMPLETE REDRAW SEE PREVIOUS REV. AFT FLOAT HOLE NOW Ø0.465 WAS Ø0.437 FINISH REMOVED FROM SADDLE AREA SEE DETAIL F. REF PART15-421 CHANGE QTY OF D2855-3, ADDED D2855-5 CAP ASSEMBLIES, ADDED INSTRUCTIONS TO LOCATE INSERT HOLE FOR D2855-6 CAP, REF PART17-583 ADDED DRILL JIG REF NUMBER, NCR15-5366 INCREASE RIDGE RELIEF FROM 0.060 TO 0.130. REF PART17-574	AJS / WK	17.03.13
D	REVISED DIMENSIONS AND PROVIDED TOLERANCE TO SKIDTUBE OVERALL LENGTH PAGE 5-6 REVISED NOTE 2 AND NOTE 7 PAGE 1 (ZN B8- ZN A8-1) REVISED -041/-043/-045 DRAWING VIEWS, REVISED SECTION VIEW F-F (ZN B4-7), REVISED BOM REF. PART13-299 AND PART13-272	AK	14.08.08
C	(SHT 1 P/L, ZN C2-2, C2-3, C2-4) ITEM 13, QTY 2 WAS 4, ITEM 42 AND 45, QTY 44 WAS 48, ADD ITEM 48, MS24684- C52 WAS AN3C5A, D3672-1 AND WAS11490332R, (ZN C7-7) Ø0.201 CSK Ø0.385 X 100' WAS Ø0.204 THRU, (ZN A4-5, A4-6) ADD RELIEF INSTRUCTION, ADD ITEM 10, CROSS BOLT SPACER (ZN D4-1, C8-7, D8-7)	DB	13.02.21
B	REVISED PART LIST, ALS4-1032-130 WAS AELS-1032-130 (ZN A8-5, A5-6, C5-7, C3-7, A5-7), ADD D78932 (ZN A8-1); D2855-3 WAS D2575 (ZN C8-2, C1-2, C8-3, C1-3, C8-4, C1-4); AN3C5A WAS AN3C4A (ZN C7-2, C1-2, C7-3, C1-3, C7-4, C1-4); D3849-047 WAS D3849-041 (ZN B3-4); ADD D3411-3 (ZN B3-4); ADD AN3C50A (ZN B3-4); Ø0.313 WAS Ø0.328 (B2-5, B2-6, C2-7, A8-7 & D7-8), REVISED NOTE iv (ZN A8-7)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	WK		
CHECKED	VS	DRAWING NO.	REV. E
MFG. APPR.	DD	D3905	SHEET 1 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	A119 FLOAT SKIDTUBE ASSY	NTS
DATE	17.03.13	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED
 2017-05-08
 EN 17-519

APPROVED

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3905-041	SKIDTUBE ASSY
1	1	D2855-3	CAP
2	1	D2855-5	CAP
3	16	D3492-045	PLUG
4	2	D3672-1	PHENOLIC WASHER
5	8	D3847-1	WEARPAD
6	1	D3847-11	WEARPAD
7	1	D3905-051	SKIDTUBE SUB ASSEMBLY
8	2	D5101-041	CROSSBOLT SPACER ASSY
9	1	D5101-047	CROSSBOLT SPACER ASSY
10	6	D5101-3	INSERT
11	6	D5101-5	INSERT

ITEM	QTY -041	P/N	DESCRIPTION
12	1	ALS4-1032-225	INSERT
13	6	AN3C4A	BOLT
14	38	AN3C5A	BOLT
15	3	AN4C46A	BOLT
16	3	MS21043-4	NUT, SELF-LOCKING
17	2	MS24694-C52	SCREW, CSK 100°
18	44	NAS1149C0332R	WASHER
19	6	NAS1149C0416R	WASHER



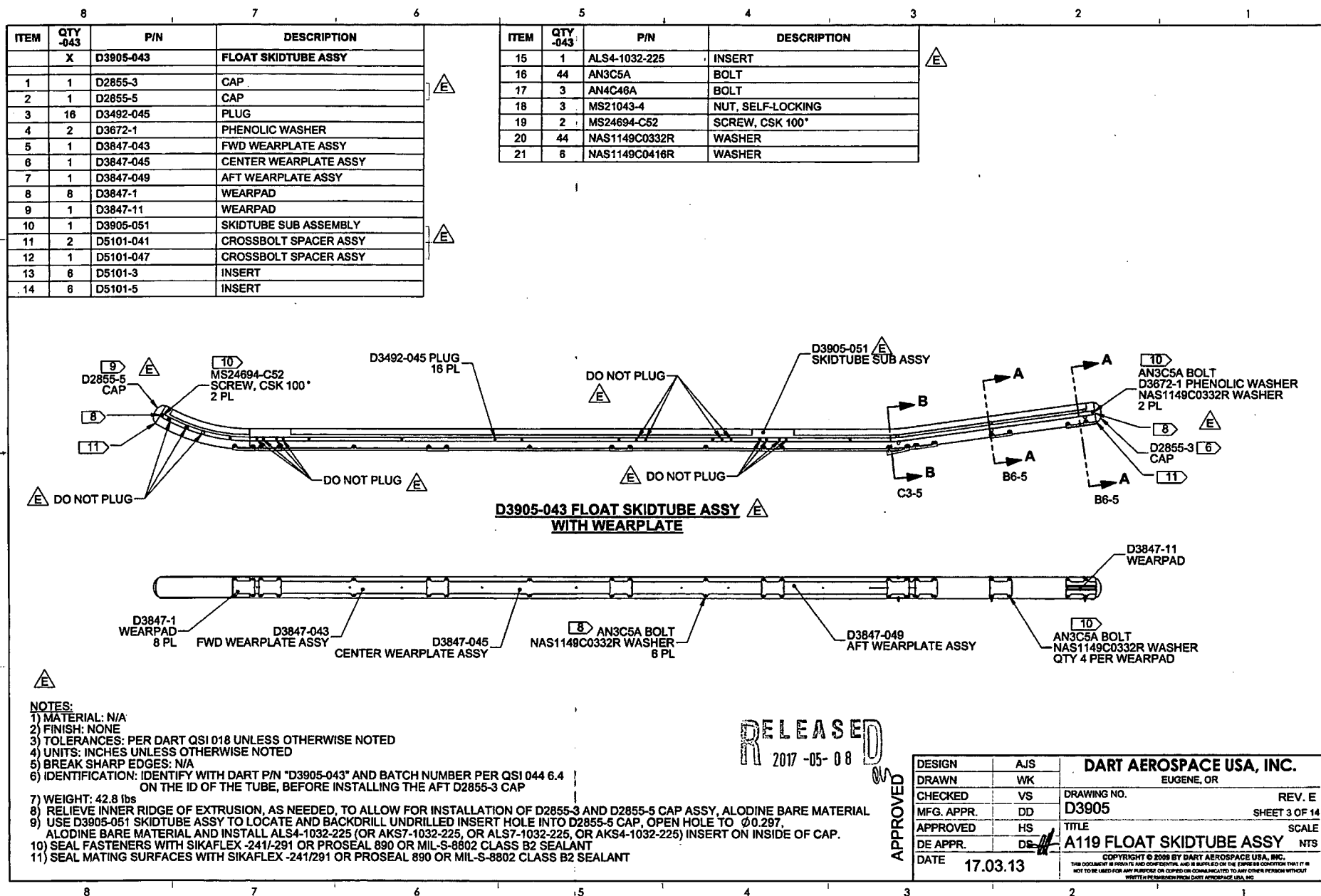
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3905-041" AND BATCH NUMBER PER QSI 044 6.4 ON THE ID OF THE TUBE, BEFORE INSTALLING THE AFT D2855-3 CAP
- 7) WEIGHT: 35.4 lbs
- 8) RELIEVE INNER RIDGE OF EXTRUSION, AS NEEDED, TO ALLOW FOR INSTALLATION OF D2855-3 AND D2855-5 CAP ASSY, ALODINE BARE MATERIAL
- 9) USE D3905-051 SKIDTUBE ASSY TO LOCATE AND BACKDRILL UNDRILLED INSERT HOLE INTO D2855-5 CAP, OPEN HOLE TO $\varnothing 0.297$, ALODINE BARE MATERIAL AND INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR ALS7-1032-225, OR AKS4-1032-225) INSERT ON INSIDE OF CAP.
- 10) SEAL FASTENERS WITH SIKAFLEX -241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 11) SEAL MATING SURFACES WITH SIKAFLEX -241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT

RELEASED
2017-05-08

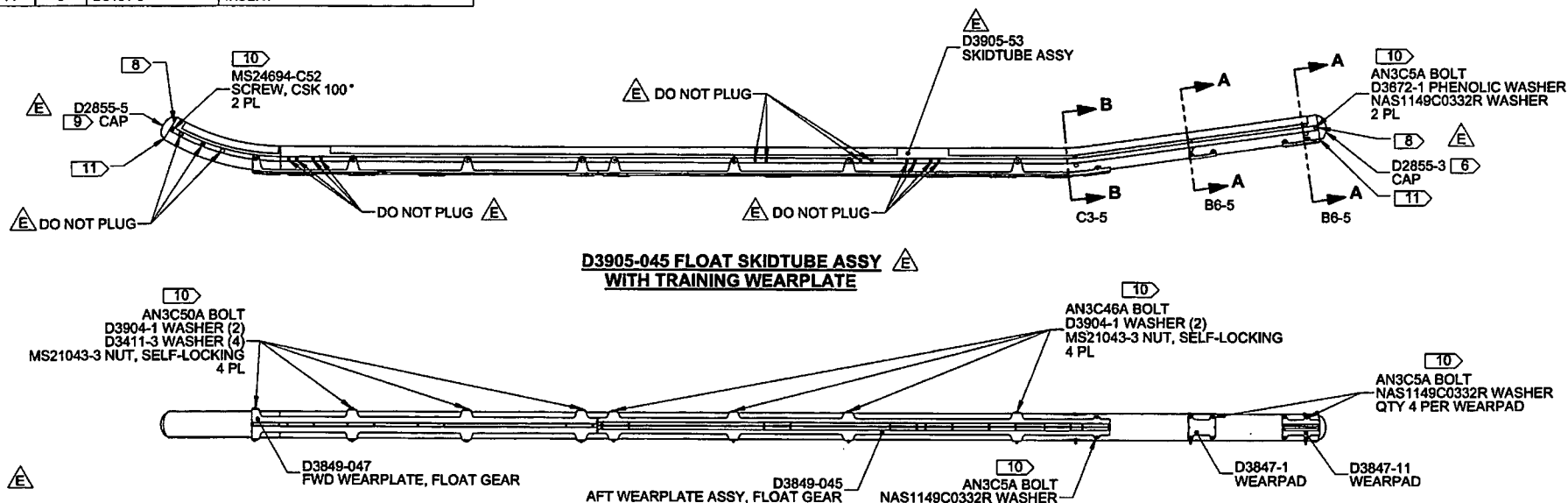
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DESIGN	AJS	DART AEROSPACE USA, INC.	
DRAWN	WK	EUGENE, OR	
CHECKED	VS	DRAWING NO.	REV. E
MFG. APPR.	DD	D3905	SHEET 2 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	A119 FLOAT SKIDTUBE ASSY	NTS
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ITEM	QTY	P/N	DESCRIPTION
	X	D3905-045	FLOAT SKIDTUBE ASSY
1	1	D2855-3	CAP
2	1	D2855-5	CAP
3	16	D3411-3	WASHER
4	2	D3872-1	PHENOLIC WASHER
5	1	D3847-1	WEARPAD
6	1	D3847-11	WEARPAD
7	1	D3849-045	AFT WEARPLATE ASSY, FLOAT GEAR
8	1	D3849-047	FWD WEARPLATE, FLOAT GEAR
9	16	D3904-1	WASHER
10	1	D3905-053	SKIDTUBE SUB ASSEMBLY
11	2	D5101-041	CROSSBOLT SPACER ASSY
12	1	D5101-047	CROSS BOLT SPACER
13	6	D5101-3	INSERT
14	6	D5101-5	INSERT

ITEM	QTY	P/N	DESCRIPTION
15	1	ALS4-1032-225	INSERT
16	12	AN3C5A	BOLT
17	4	AN3C46A	BOLT
18	4	AN3C50A	BOLT
19	3	AN4C46A	BOLT
20	8	MS21043-3	NUT, SELF-LOCKING
21	3	MS21043-4	NUT, SELF-LOCKING
22	2	MS24694-C52	SCREW, CSK 100°
15	12	NAS1149C0332R	WASHER
24	6	NAS1149D0416J	WASHER



NOTES:

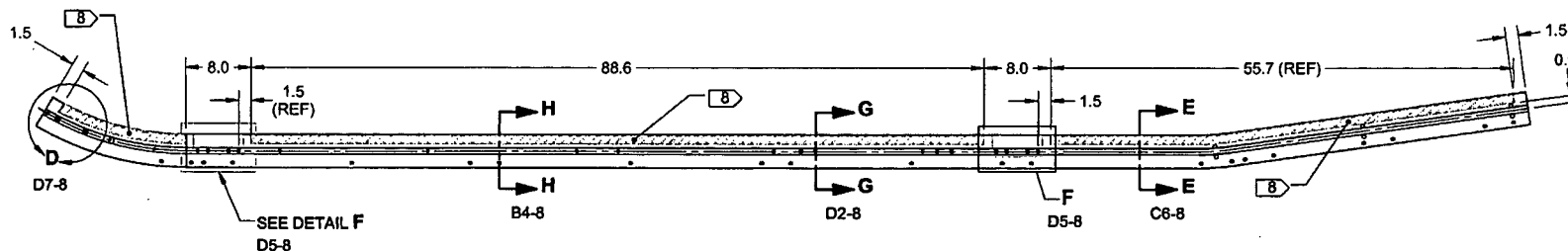
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3905-045" AND BATCH NUMBER PER QSI 044 6.4 ON THE ID OF THE TUBE, BEFORE INSTALLING THE AFT D2855-3 CAP
- 7) WEIGHT: 48.0 lbs
- 8) RELIEVE INNER RIDGE OF EXTRUSION, AS NEEDED, TO ALLOW FOR INSTALLATION OF D2855-3 AND D2855-5 CAP ASSY, ALODINE BARE MATERIAL
- 9) USE D3905-053 SKIDTUBE ASSY TO LOCATE AND BACKDRILL UNDRILLED INSERT HOLE INTO D2855-5 CAP, OPEN HOLE TO $\phi 0.297$, ALODINE BARE MATERIAL AND INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR ALS7-1032-225, OR AKS4-1032-225) INSERT ON INSIDE OF CAP.
- 10) SEAL FASTENERS WITH SIKAFLEX -241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 11) SEAL MATING SURFACES WITH SIKAFLEX -241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT

RELEASED
2017-05-08

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DESIGN	AJS	DART AEROSPACE USA, INC.	
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CHECKED	VS	DRAWING NO.	REV. E
MFG. APPR.	DD	D3905	SHEET 4 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	A119 FLOAT SKIDTUBE ASSY	NTS
DATE	17.03.13	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

ITEM	QTY	P/N	DESCRIPTION
	X	D3905-051	SKIDTUBE SUB ASSY
1	2	D2579	CROSS BOLT SPACER
2	8	D3681-1	SPACER
3	12	D3903-1	SPACER
4	1	D3905-061	SKIDTUBE SUB ASSEMBLY
5	42	ALS4-1032-130	INSERT



D3905-051 SKIDTUBE SUB ASSEMBLY

NOTES:

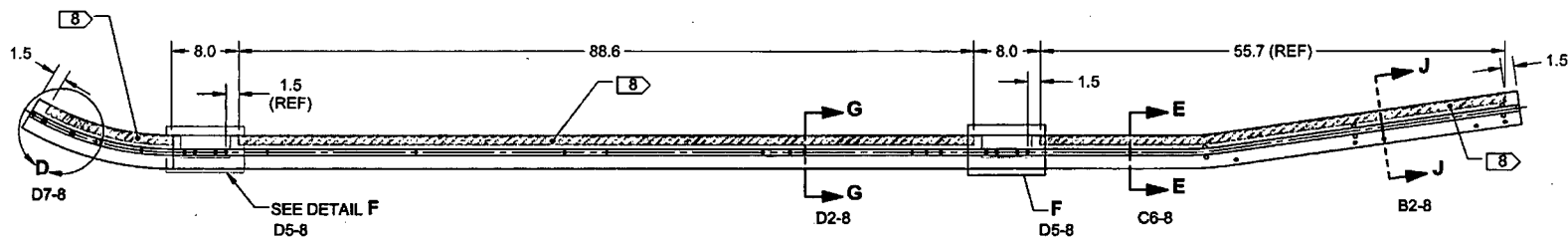
- 1) MATERIAL: N/A
- 2) FINISH: PRIME (REF 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2.2.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY AT NEXT ASSEMBLY
- 7) WEIGHT: N/A
- 8) AFTER APPLICATION OF FINISH, PAINT TOP SURFACE OF SKIDTUBE WITH MIL-W-5044 ANTI-SKID PAINT (WING WALK) AS INDICATED TO 0.50" ABOVE LOCATION RIDGE, PER QSI 005 SECTION 4.4

RELEASED
2017-05-08

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DESIGN	AJS	DART AEROSPACE USA, INC.	
DRAWN	WK	EUGENE, OR	
CHECKED	VS	DRAWING NO.	REV. E
MFG. APPR.	DD	D3905	SHEET 6 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	A119 FLOAT SKIDTUBE ASSY	NTS
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ITEM	QTY	P/N	DESCRIPTION
	X	D3905-053	SKIDTUBE SUB ASSY
1	2	D2579	CROSS BOLT SPACER
2	8	D3681-1	SPACER
3	12	D3903-1	SPACER
4	1	D3905-063	SKIDTUBE SUB ASSEMBLY
5	10	ALS4-1032-130	INSERT



D3905-053 SKIDTUBE SUB ASSEMBLY

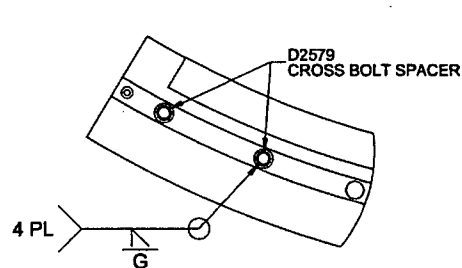
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME (REF 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2.2.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY AT NEXT ASSEMBLY
- 7) WEIGHT: N/A
- 8) AFTER APPLICATION OF FINISH, PAINT TOP SURFACE OF SKIDTUBE WITH MIL-W-5044 ANTI-SKID PAINT (WING WALK) AS INDICATED TO 0.50" ABOVE LOCATION RIDGE, PER QSI 005 SECTION 4.4

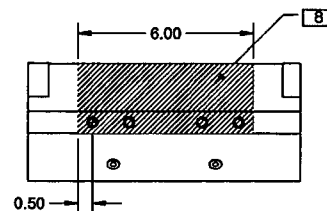
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DESIGN	AJS	DART AEROSPACE USA, INC.	
DRAWN	WK	EUGENE, OR	
CHECKED	VS	DRAWING NO.	REV. E
MFG. APPR.	DD	D3905	SHEET 7 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	A119 FLOAT SKIDTUBE ASSY	NTS
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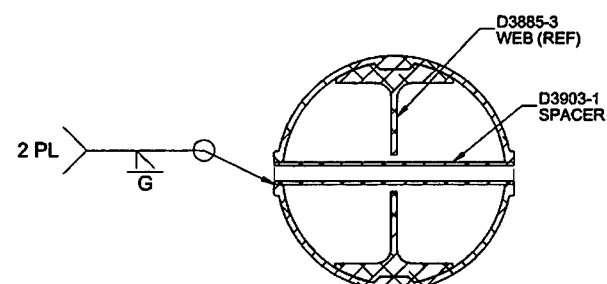
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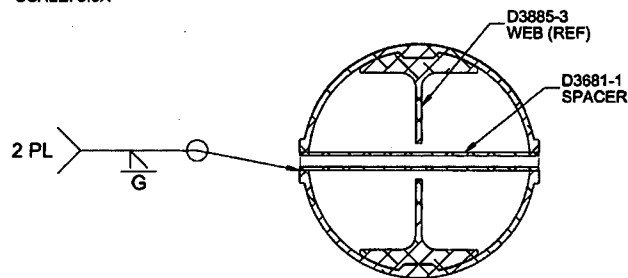
DETAIL D
SCALE: 3.5X



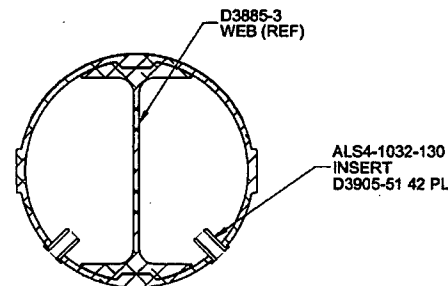
DETAIL F
SCALE: 3.5X



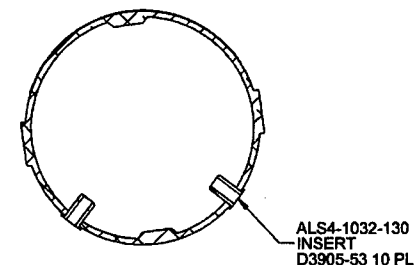
SECTION G-G
SCALE: 7X
12 PL



SECTION E-E
SCALE: 7X
8 PL



SECTION H-H
SCALE: 7X
D3905-51 21 PL



SECTION J-J
SCALE: 7X
D3905-53 5 PL

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME (REF 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2.2.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A
- 8) MASK THIS AREA AND DO NOT APPLY PRIMER OR PAINT
- 9) AFTER DRILLING AND BENDING ASSEMBLY, PERFORM THE FOLLOWING FOR THE SECTION G-G $\phi 0.375$ HOLES ONLY:
 - i) CHAMFER HOLES $\phi 0.475 \times 45^\circ$
 - ii) INSERT D3903-1 SPACER
 - iii) WELD INTO PLACE AND GRIND FLUSH
 - iv) CBORE TO $\phi 0.313 \times 0.75$ DEEP
 - v) DEBURR HOLES
- 10) AFTER DRILLING AND BENDING ASSEMBLY, PERFORM THE FOLLOWING FOR THE SECTION E-E $\phi 0.313$ HOLES ONLY:
 - i) CHAMFER HOLES $\phi 0.354 \times 45^\circ$ OR 0.050 DEEP $\times 45^\circ$ (BOTH SIDES)
 - ii) INSERT D3681-1 SPACER
 - iii) WELD INTO PLACE AND GRIND FLUSH
 - iv) DEBURR HOLES
- 11) WELD PER DART QSI 004

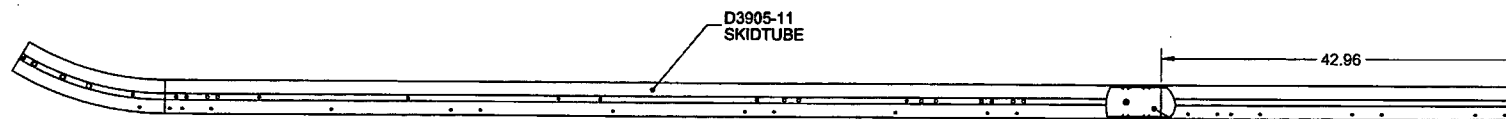
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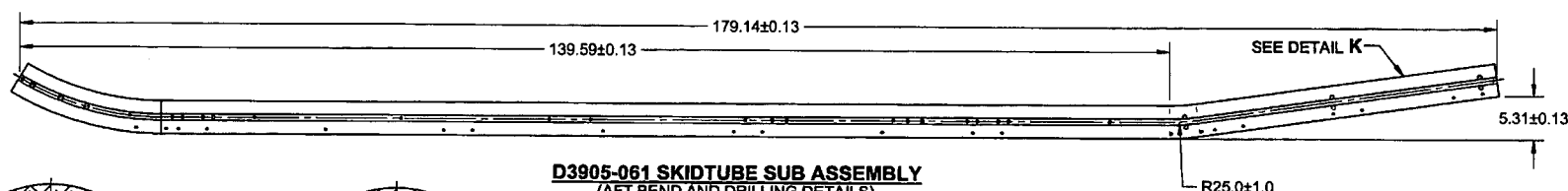
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8 7 6 5 4 3 2 1

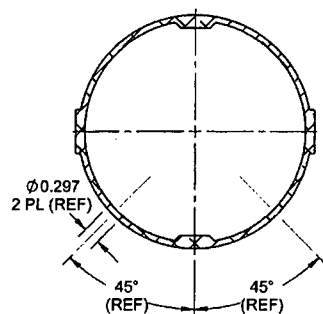
ITEM	QTY -061	P/N	DESCRIPTION
		D3905-061	SKIDTUBE SUB ASSEMBLY
1	1	D3885-3	FLOAT WEB
2	1	D3905-11	SKIDTUBE



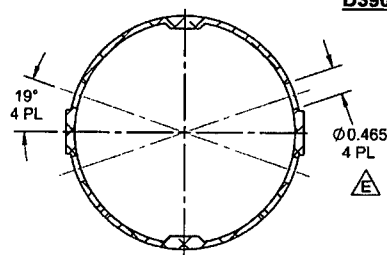
D3905-061 SKIDTUBE SUB ASSEMBLY
(WEB/TUBE ASSEMBLY PRIOR TO AFT BEND)



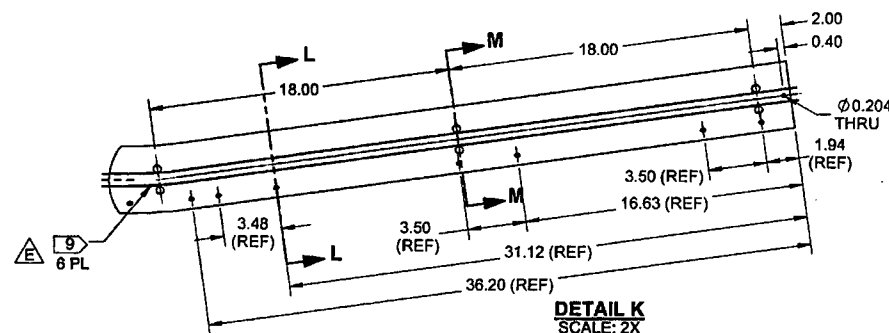
D3905-061 SKIDTUBE SUB ASSEMBLY
(AFT BEND AND DRILLING DETAILS)



SECTION L-L
7 PL
SCALE: 7X



SECTION M-M
3 PL
SCALE: 7X



NOTES:

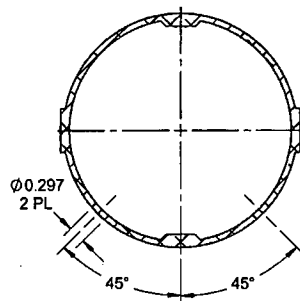
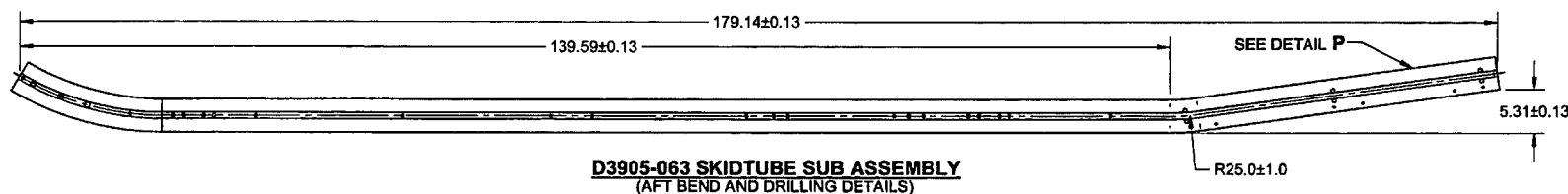
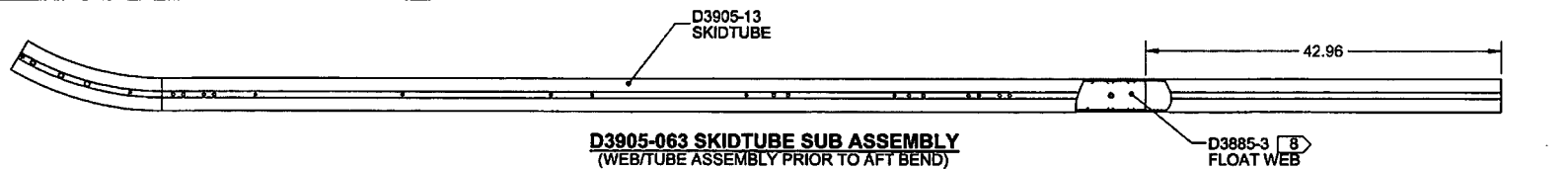
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A
- 8) INSERT D3885-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING. ENSURE HOLES LINE-UP
- 9) RELIEVE RIDGE FLUSH WITH SKIDTUBE FOR INSERT CLEARANCE, MAX 0.130 INTO RIDGE

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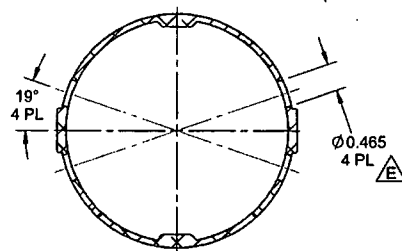
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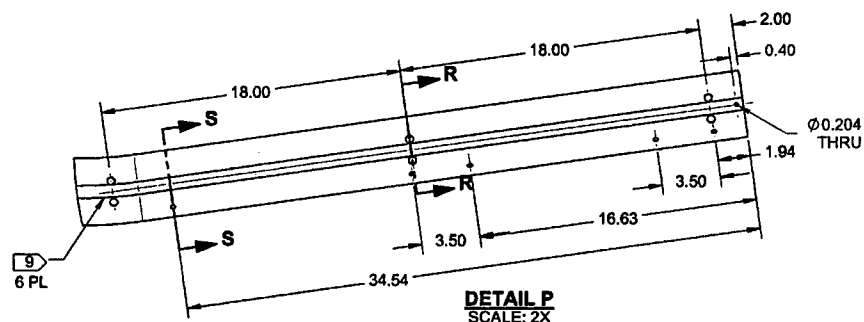
ITEM	QTY .063	P/N	DESCRIPTION
	X	D3905-063	SKIDTUBE SUB ASSEMBLY
1	1	D3885-3	FLOAT WEB
2	1	D3905-13	SKIDTUBE



SECTION S-S
5 PL
SCALE: 7X



SECTION R-R
3 PL
SCALE: 7X



DETAIL P
SCALE: 2X

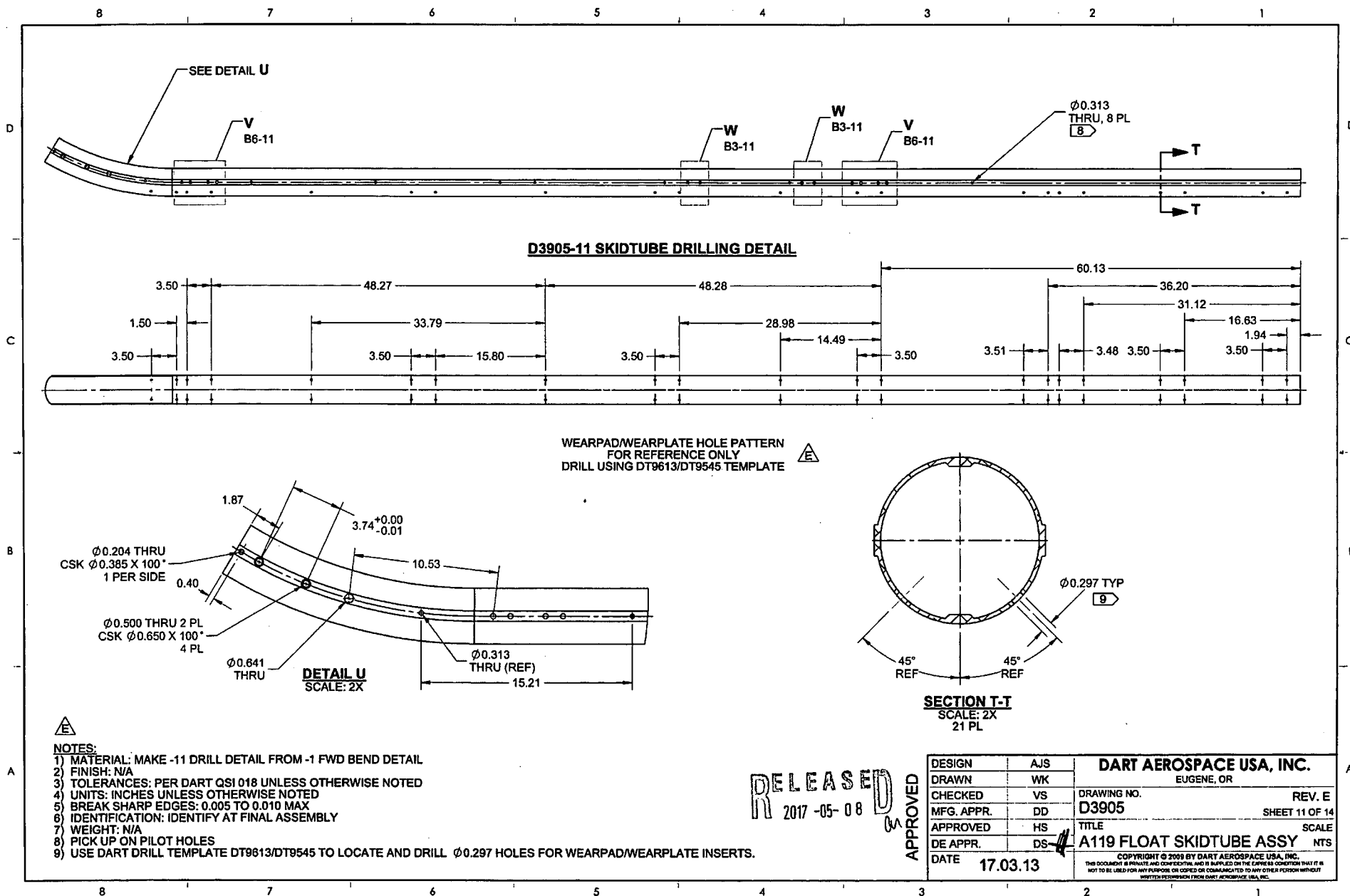
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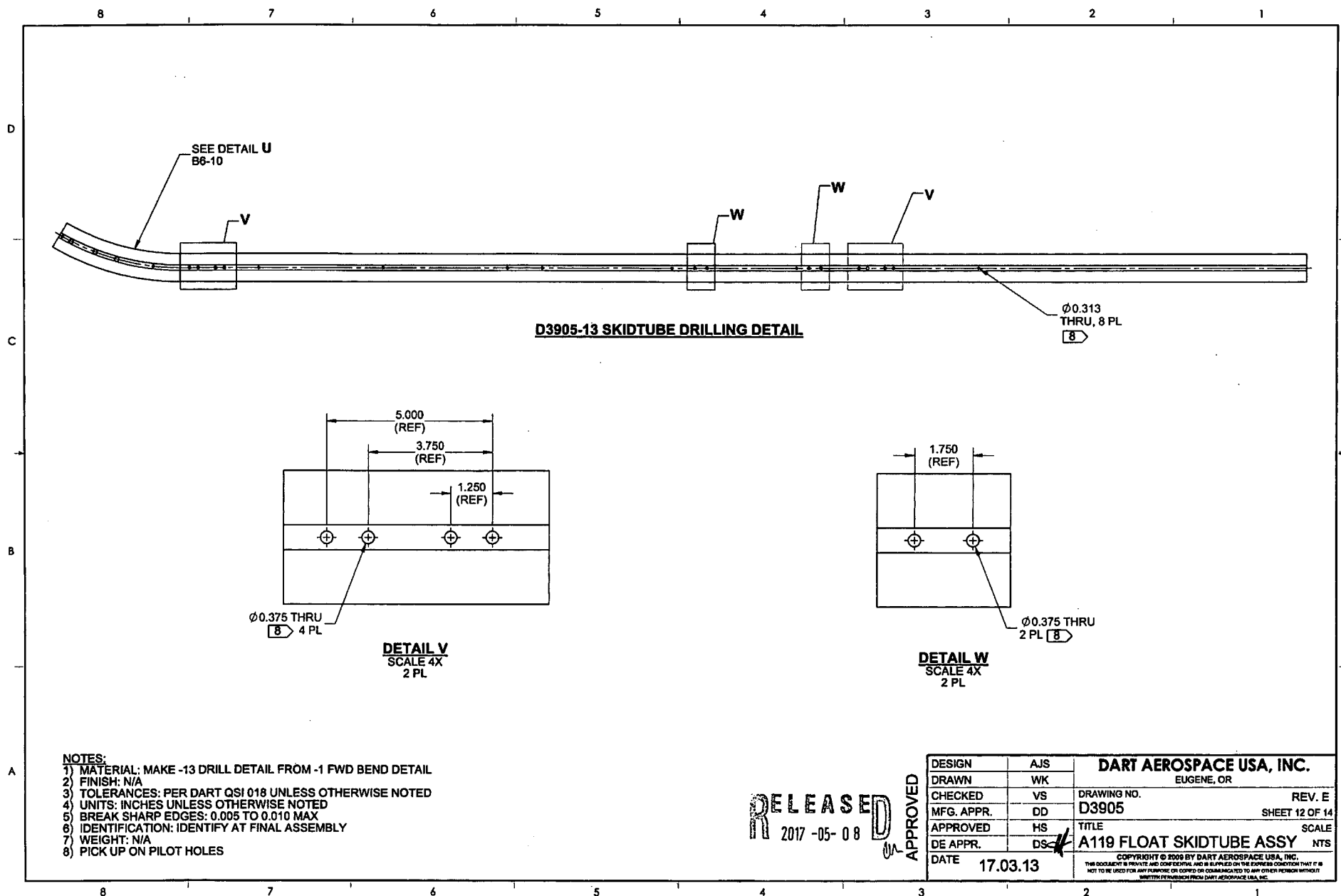
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A
- 8) INSERT D3885-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 AFTER BENDING. ENSURE HOLES LINE-UP
- 9) RELIEVE RIDGE FLUSH WITH SKIDTUBE FOR INSERT CLEARANCE, MAX 0.130 INTO RIDGE

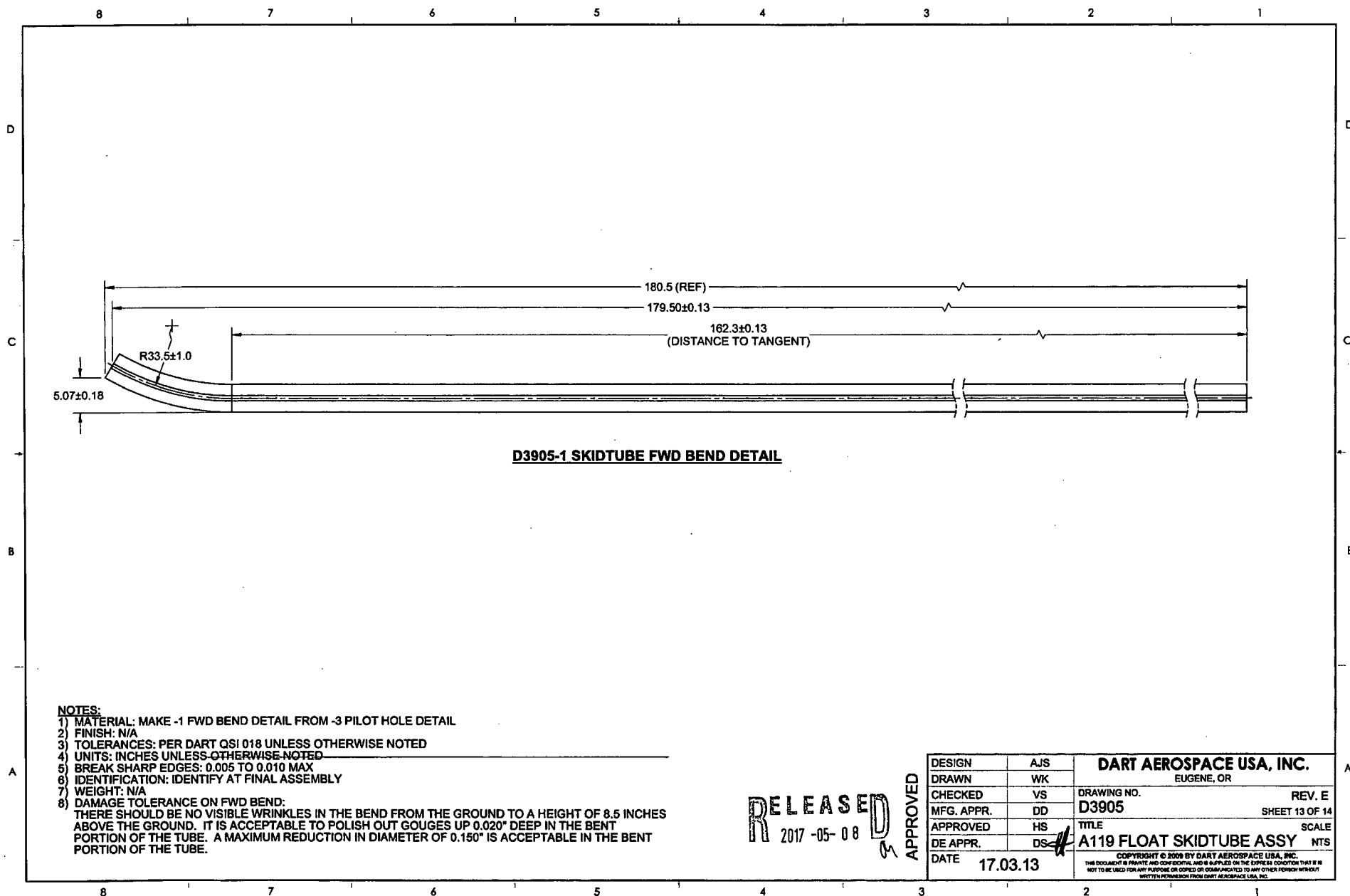
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2017-05-08

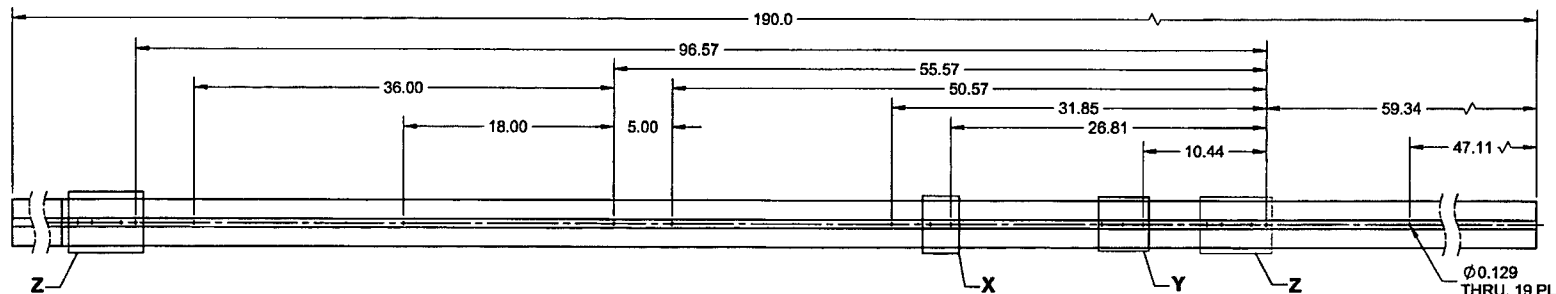
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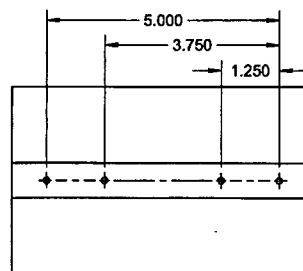




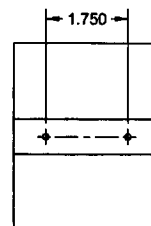




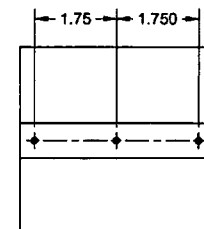
D3905-3 SKIDTUBE PILOT HOLE DETAIL



DETAIL Z
SCALE: 4X



DETAIL X
SCALE: 4X



DETAIL Y
SCALE: 4X

NOTES:

- 1) MATERIAL: MAKE FROM D2500-1-190 EXTRUSION
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A

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DRAWING NO. **D3905** REV. E
SHEET 14 OF 14
TITLE **A119 FLOAT SKIDTUBE ASSY** SCALE NTS

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